

Application No: 10/666,379 Docket No.: Q137-US10

Page 2

IN THE CLAIMS**RECEIVED
CENTRAL FAX CENTER
DEC 20 2006**

Please amend the claims as follows:

1.-65. (canceled)

66. (new) A method of forming a battery, comprising:

arranging battery components such that

an electrode is in electrical communication with a pin,

an electrode is electrically insulated from the pin,

 a tab provides electrical communication between an end cap and the
 electrode that is electrically isolated from the pin,

the electrodes are positioned in a case and are wound around the pin, and

the end cap is configured to close an opening in the case;

 transporting electrolyte through the opening and into the case while resting the
end cap on the case with an edge of the case positioned between the tab and the case, the
edge defining the opening; and

sealing the opening with the end cap.

67. (new) The method of claim 66, wherein the tab is connected to the end cap such that
resting the end cap on the case holds the end cap in an orientation that is substantially
perpendicular to the opening.68. (new) The method of claim 66, wherein a weld connects a flat portion of the tab to
an inner face the end cap.

69. (new) The method of claim 66, wherein:

the end cap has a radius; and

 the opening is sealed with the cap such that the tab is positioned adjacent to the
end cap without being connected to the end cap for a distance that is greater than the
radius.

Application No: 10/666,379 Docket No.: Q137-US10

Page 3

70. (new) The method of claim 66, wherein the tab is connected to a connection location on the end cap and the end cap is rested on the case such that the connection location is above a center point on the end cap.

71. (new) The method of claim 66, wherein:

the end cap has a radius; and

the end cap is rested on the case such the end cap overlaps the case by at least an amount that exceeds the radius.

72. (new) The method of claim 66, wherein the opening is sealed with the end cap such that the tab extends from a first location adjacent to the case past a center point of the end cap to a second location where the tab is electrically connected to the end cap.

73. (new) The method of claim 72, wherein the tab is not connected to the end cap continuously over a distance extending from the first location to the second location.

74. (new) The method of claim 66, wherein the electrodes are electrode strips wound around the pin so as to form a spiral role on the pin.

75. (new) The method of claim 74, wherein the spiral role includes at least one separator separating the electrodes.

76. (new) The method of claim 66, wherein a mandrel is mounted on the pin such that the electrodes are wound around the pin and the mandrel.

77. (new) The method of claim 76, wherein the mandrel includes a longitudinal slot; and wherein

one of the electrodes is in electrical communication with the pin and also extends through the mandrel slot.

Application No: 10/666,379 Docket No.: Q137-US10

Page 4

78. (new) The method of claim 76, wherein the electrodes in electrical communication with the pin includes a region that is positioned between the mandrel and the pin.

79. (new) The method of claim 76, wherein the electrodes in electrical communication with the pin includes active material positioned on a substrate, the substrate is positioned between the mandrel and the pin without the active material being positioned between the mandrel and the pin.

80. (new) The method of claim 76, wherein the mandrel is crimped onto the pin.

81. (new) The method of claim 76, wherein a weld attaches the mandrel to the pin.

82. (new) The method of claim 76, wherein the mandrel includes titanium or an alloy of titanium.

83. (new) The method of claim 76, wherein the mandrel includes a tube.

84. (new) The method of claim 80, wherein the pin is positioned in an interior of the tube.

85. (new) The method of claim 76, wherein the mandrel has a c-shaped cross-section.

86. (new) The method of claim 76, wherein the mandrel is fitted around the pin such that the electrodes are wound around the pin and the mandrel.

87. (new) The method of claim 76, wherein the mandrel is a reinforcing mandrel.

88. (new) The method of claim 66, wherein at least one weld directly connects the pin the electrode in electrical communication with the pin.

89. (new) The method of claim 66, wherein the pin includes of a PtIr alloy.

Application No: 10/666,379 Docket No.: Q137-US10

Page 5

90. (new) The method of claim 66, wherein the end cap includes
an electrical insulator,
the pin extends through the electrical insulator, and
the pin is hermetically sealed to the electrical insulator.

91. (new) The method of claim 66, wherein the case is electrically conducting.